

What is claimed is:

1. A laminate film, comprising:
a biaxially oriented polymer film substrate;
a metal-containing layer; and
an EVOH layer coextruded or laminated directly on the metal-containing layer.
2. The laminate film of claim 1, wherein the polymer film comprises a polymer selected from the group consisting of polyolefin, polyester, polyamide and combinations thereof.
3. The laminate film of claim 1, wherein the polymer film comprises polyolefin.
4. The laminate film of claim 1, wherein the metal-containing layer is a vacuum metallized layer.
5. The laminate film of claim 1, further comprising an adjacent layer of anhydride modified polyolefin on the EVOH layer.
6. The laminate film of claim 5, wherein the adjacent layer comprises a blend of a polyolefin resin and maleic anhydride modified adhesive resin, wherein the polyolefin resin is a low density polyethylene, a medium density polyethylene, polypropylene or combination thereof.

7. The laminate film of claim 5, further comprising a second film layer on the adjacent layer, the second film layer comprising polypropylene, poly(ethylene terephthalate), or combination thereof.
8. The laminate film of claim 7, wherein the second film layer is vacuum metallized or non-metallized.
9. The laminate film of claim 7, further comprising a second barrier layer directly on the EVOH layer, the second barrier layer comprising a material selected from the group consisting of amorphous nylon and PVDC.
10. The laminate film of claim 1, wherein the structure has a oxygen transmission rate of $0.5 \text{ cc/m}^2/\text{day}$ or less.
11. The laminate film of claim 1, wherein the structure has a oxygen transmission rate of $0.35 \text{ cc/m}^2/\text{day}$ or less.
12. The laminate film of claim 1, wherein the structure has a oxygen transmission rate of $0.2 \text{ cc/m}^2/\text{day}$ or less.
13. The laminate film of claim 1, further comprising:

a heat sealable layer or winding layer comprising an antiblock component selected from the group consisting of amorphous silicas, aluminosilicates, sodium calcium aluminum silicate, a crosslinked silicone polymer and polymethylmethacrylate.

14. The laminate film of claim 13, wherein said heat-sealable layer or winding layer has a thickness of about 0.5 to 5.0 μm .

15. The laminate film of claim 1, wherein said substrate has a thickness of about 6 to 40 μm .

16. The laminate film of claim 4, wherein said metal-containing layer has an optical density of about 1.5 to 5.0.

17. The laminate film of claim 1, wherein said substrate is discharge-treated in an atmosphere of CO_2 and N_2 .

18. The laminate film of claim 1, wherein the metal-containing layer comprises aluminum.

19. The laminate film of claim 1, wherein the metal-containing layer is a metal layer, a metal oxide layer or combinations thereof.

20. The laminate film of claim 19, wherein the metal oxide is aluminum oxide, silicon oxide or combinations thereof.
21. A method of manufacturing a laminate film, comprising:
extruding a biaxially oriented polymer film substrate;
applying a metal-containing layer on the substrate; and
applying a coextruded or laminated EVOH layer directly on the metal-containing layer.
22. The method of claim 21, further applying an adjacent layer of anhydride modified polyolefin on the EVOH layer.
23. The method of claim 21, further applying a second film layer on the adjacent layer, the second film layer comprising polypropylene, poly(ethylene terephthalate), or combination thereof.